

SHIP TODAY ON 4/12-7/2013 TODAY

Work Order ID 58116

April 26, 2010 8:31:57 AM

Page 1

Item ID: D4095-3

Accept

Revision ID: PRELIM

Item Name: Wearplate

Start Date: 4/26/10

Start Qty: 2.00

Required Date: 4/26/10

Req'd Qty: 2.00

Cust Item ID:

Customer:

PRELIMINARY ISSUE

Reference:

Approvals:

Process Plan: *W*

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4095

PA1 PA3



0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D4095

Dwg Rev: *PA3*

Prog Rev:

2-Deburr if necessary

IB 10-4-26

(2)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B10-4-26

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

*- inspect to PA3 Dwg
8/2/06 #2*

Work Order ID 58116

April 26, 2010 8:31:57 AM



Page 2

Item ID:	D4095-3	Accept		Setup	Start	
Revision ID:	PRELIM				Stop	
Item Name:	Wearplate					
Start Date:	4/26/10	Start Qty: 2.00		Cust Item ID:		
Required Date:	4/26/10	Req'd Qty: 2.00		Customer:	1	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Brake NC	NC BRAKE	0.00							
Brake NC	Memo 1- bend section C-C first 2- Form on Brake as per Dwg D4095 using Jigs DT 8179 and DT 8155 3- Form Joggles (2) as per Dwg D4095 on brake using Jig DT 8157	0.00							
140 QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo Ensure joggle as per dwg D4095	0.00							
150 Large Fab	Weld per dwg A/R Hardcoat S.S. Batch: _____ Large Fab	0.00							
Large Fab	Memo same template as D3564-1-3	0.00							

SB 10/04/26

*- Rteam sketched.
Fit not BAD
inspected by POC Day.*

12 10-4-26

Work Order ID 58116

April 26, 2010 8:31:58 AM



Page 3

Item ID:	D4095-3	Accept		Setup	Start	
Revision ID:	PRELIM				Stop	
Item Name:	Wearplate					
Start Date:	4/26/10	Start Qty: 2.00		Cust Item ID:		
Required Date:	4/26/10	Req'd Qty: 2.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 8/10/04/26 0.00							
170 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 - Fit good. - weld good 0.00 - inspection to pass duty.							8/10/04/26
180 Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 M112588 Memo START TIME: 1:15pm OVEN TEMPERATURE: 320°C FINISH TIME: 1:45pm	0.00 0.00						X2	Q

Work Order ID 58116

April 26, 2010 8:31:58 AM



Page 4

Item ID: D4095-3

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Wearplate

Start Date: 4/26/10

Start Qty: 2.00



Cust Item ID:

Required Date: 4/26/10

Req'd Qty: 2.00



Customer:

PRELIMINARY ISSUE

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

2 *BF* 10-4-26

200

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

BF 10-4-26

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

POSITIVE RECALL

EFFECTIVE

10/10/07

AUTH

h

RELEASED

h

DATE

10.10.07

10/10/07 *h*

mf
10-4-27

Picklist Print

April 26, 2010 8:31:56 AM

Page 1

Work Order ID: 58116

Parent Item: D4095-3

Parent Item Name: Wearplate

Comments: IPP Rev:A new issue DD 10.04.21 verified by:EC

Start Date: 4/26/10

Required Date: 4/26/10

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	182.6000	4.6152			



304/316 Sheet .063



1810-4-26

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

182.6

111323

0

114467

182.6

114467

2

DART AEROSPACE LTD		Work Order: 58116
Description: WEAR PLATE		Part Number: D4095-3
Inspection Dwg: D4095-3, Rev: PA3		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒

First Article

☒

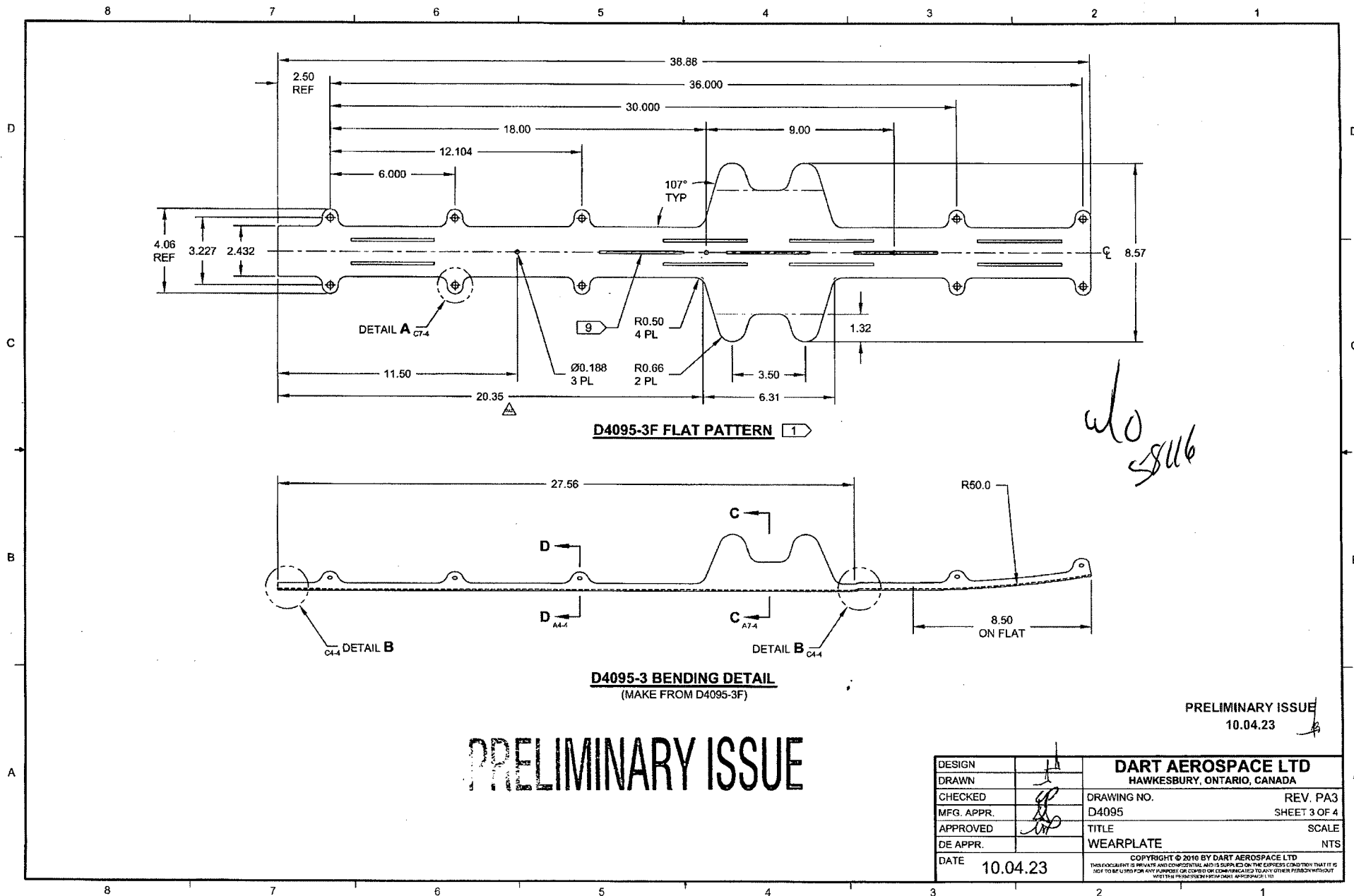
Prototype

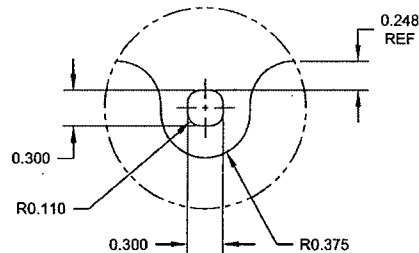
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.300	± .010	.307	✓			
.300	± .010	.308	✓			
φ .188	± .005-.001	.193	✓			
2.432	± .010	2.439	✓			
3.227	± .010	3.222	✓			
4.06	± .030	4.055	✓			
11.50	± .030	11.50	✓			
20.35	± .030	20.35	✓			
6.31	± .030	6.315	✓			
3.50	± .030	3.500	✓			
1.32	± .030	1.324	✓			
8.57	± .030	8.561	✓			
2.50	± .030	2.500	✓			
6.00	± .010	6.007	✓			
12.104	± .010	12.104	✓			
18.00	± .030	18.000	✓			
9.00	± .030	9.000	✓			
30.000	± .010	30.000	✓			
36.000	± .010	36.000	✓			
38.88	± .030	38.875	✓			
1063	± .010	1059	✓			

Measured by: HB	Audited by: S	Prototype Approval:
Date: 10-4-26	Date: 10/4/26	Date:

inspected by PA3.

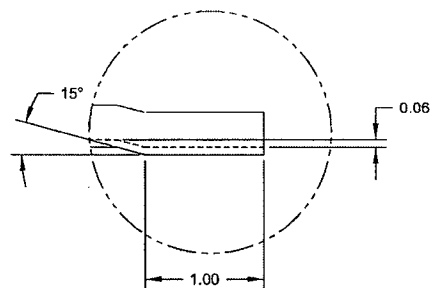
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	





DETAIL A: TAB DETAIL

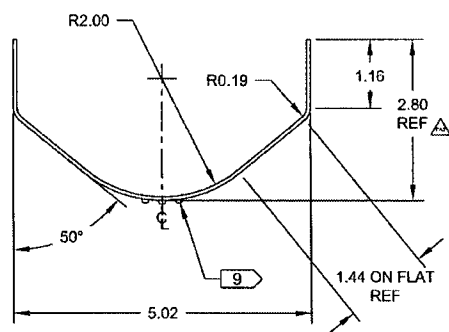
SCALE 4X C3.2
C6.3



DETAIL B: JOGGLE DETAIL

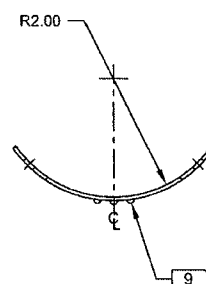
SCALE 4X B2.2
B6.2
B4.3
B7.3

PRELIMINARY ISSUE



SECTION C-C

SCALE 2X B5.2
B4.3



SECTION D-D

SCALE 2X

58116

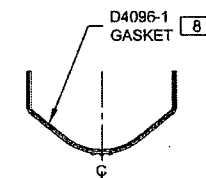
PRELIMINARY ISSUE
10.04.23

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. PA3
CHECKED		D4095	SHEET 4 OF 4
MFG. APPR.		TITLE	SCALE
APPROVED		WEARPLATE	NTS
DE APPR.		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.04.23		

PRELIMINARY ISSUE

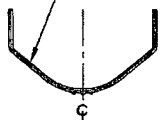
ITEM	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
1	X		D4095-041	WEARPLATE ASSEMBLY
2		X	D4095-043	WEARPLATE ASSEMBLY
3	1		D4095-1	WEARPLATE
4		1	D4095-3	WEARPLATE
5	1		D4096-1	GASKET
6		1	D4096-3	GASKET
7	A/R	A/R	1300 (OR 1300L)	3M SCOTCH-GRIP ADHESIVE

D4095-1
WEARPLATE

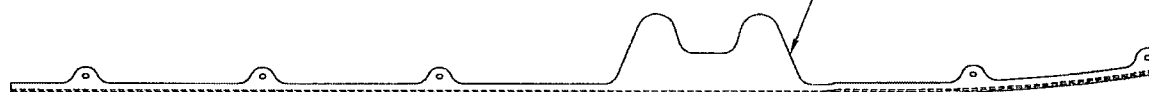


△ D4095-041 WEARPLATE ASSEMBLY

D4096-3
GASKET 8



D4095-3
WEARPLATE

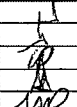


△ D4095-043 WEARPLATE ASSEMBLY

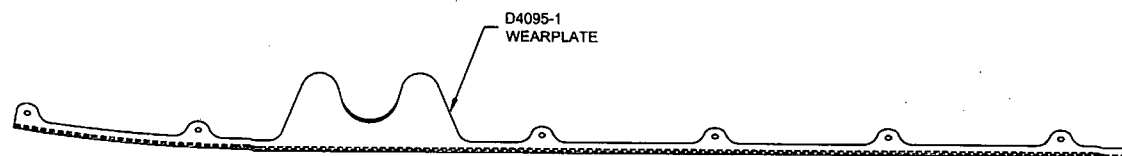
PRELIMINARY ISSUE
10.04.23

D4095-041/-043 NOTES:

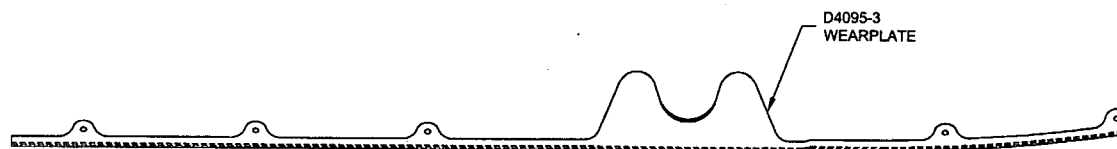
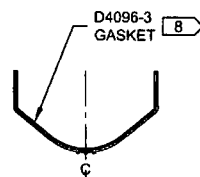
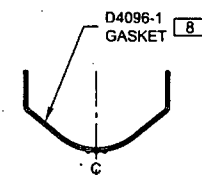
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4095-04X" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D4095-041 = 2.60 lbs; D4095-043 = 2.58 lbs
- 8) AFTER FINISH, BOND GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

PA3	ADDED D4095-041/-043; 20.35 WAS 20.69 (ZN C6-3); DIM 2.80 REF WAS 2.72 (ZN B6-4)	MB	10.04.23
PA2	ADDED CLEARANCE FOR INSIDE SADDLE INCREASED EDGE DISTANCE ON SAME PROFILE	MB	10.04.22
PA1	NEW ISSUE	MB	10.04.20
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. PA3
CHECKED		D4095	SHEET 1 OF 4
MFG. APPR.		TITLE	SCALE
APPROVED		WEARPLATE	NTS
DE APPR.			
DATE	10.04.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

ITEM	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
1	X		D4095-041	WEARPLATE ASSEMBLY
2		X	D4095-043	WEARPLATE ASSEMBLY
3	1		D4095-1	WEARPLATE
4		1	D4095-3	WEARPLATE
5	1		D4096-1	GASKET
6		1	D4096-3	GASKET
7	A/R	A/R	1300 (OR 1300L)	3M SCOTCH-GRIP ADHESIVE



D4095-041 WEARPLATE ASSEMBLY



D4095-043 WEARPLATE ASSEMBLY

58116

RELEASED
2010-09-07

D4095-041/-043 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4095-04X" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D4095-041 = 2.60 lbs; D4095-043 = 2.58 lbs
- 8) AFTER FINISH, BOND GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE
- 9) PARTS ARE SYMMETRIC ABOUT \bar{C}

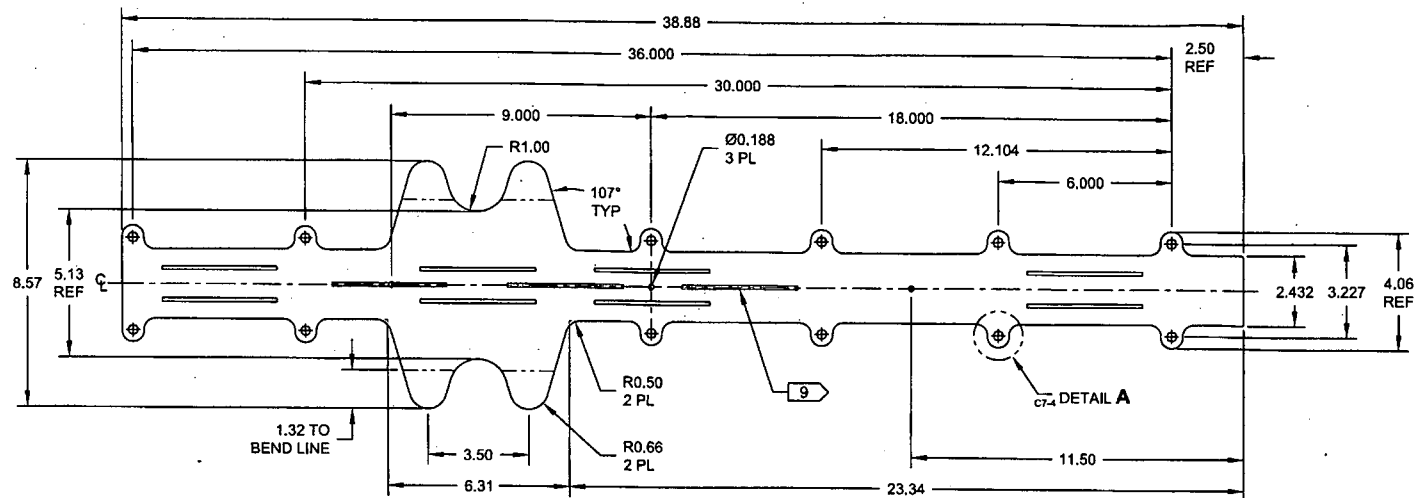
REV.	NEW ISSUE	DESCRIPTION	MB	10.04.20
DESIGN			BY	DATE
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	10.04.20			

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

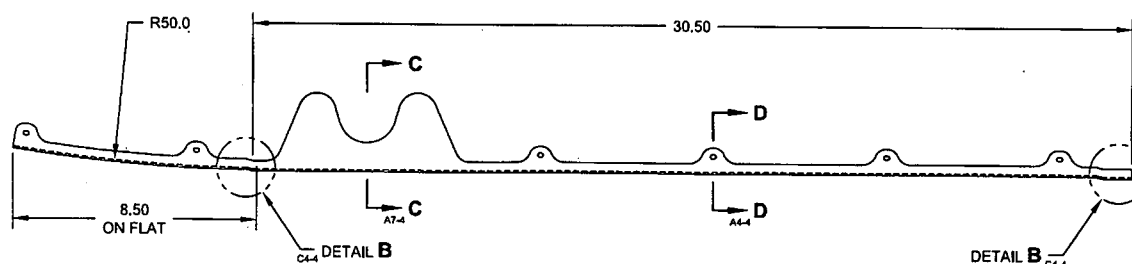
DRAWING NO. D4095
REV. A
SHEET 1 OF 4

TITLE WEARPLATE
SCALE NTS

COPYRIGHT © 2010 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



D4095-1F FLAT PATTERN 1



D4095-1 BENDING DETAIL
(MAKE FROM D4095-1F)

D4095-1F-3F-3F NOTES:

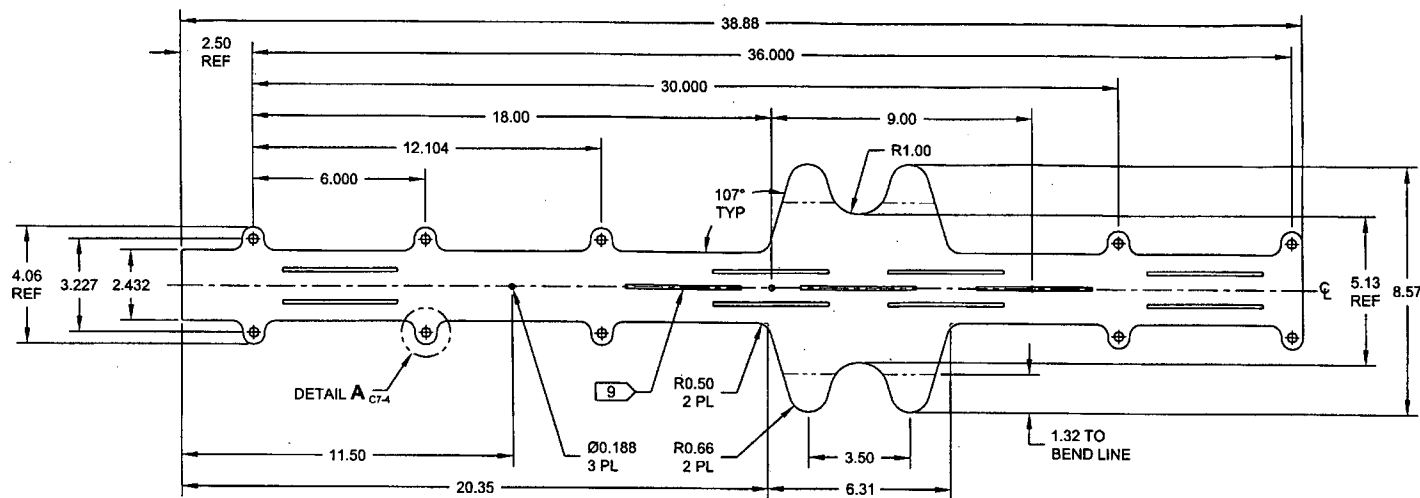
- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)
PER AMS 5513 (304) OR AMS 5524 (316), OR ASTM A240 OR ASME SA240
REF DART MATERIAL SPEC M304S16GA
- 2) FINISH: POWDER COAT GREY SANTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4095-1 = 2.18 lbs; D4095-3 = 2.16 lbs
- 8) WELDING: PER DART QSI 004
- 9) 2059B HARDCOAT WELD: 4.0 LONG X 0.063 TO 0.125 HIGH, 11 PL
WELD AFTER BENDING AS ILLUSTRATED PER DT8308
- 10) PARTS ARE SYMMETRIC ABOUT C

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. A
MFG. APPR.		D4095 SHEET 2 OF 4
APPROVED		TITLE SCALE
DE APPR.		WEARPLATE NTS
DATE	10.04.20	

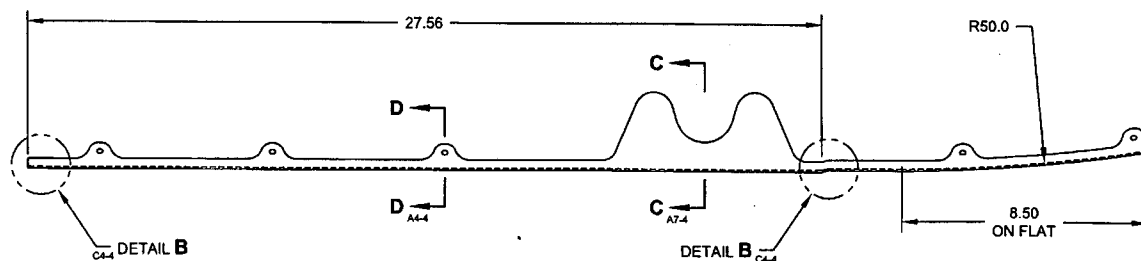
COPYRIGHT © 2010 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRELIMINARY AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD.

RELEASED
2010-08-07

58116



D4095-3F FLAT PATTERN 1

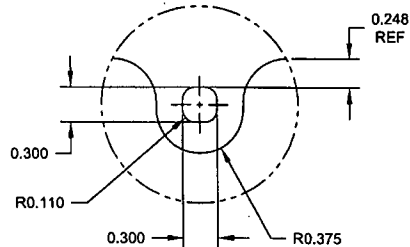


D4095-3 BENDING DETAIL
(MAKE FROM D4095-3F)

58116

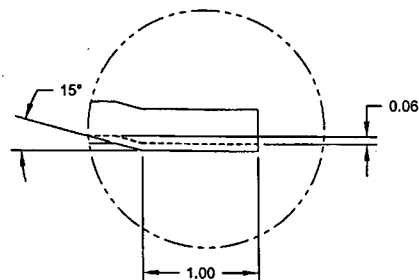
RELEASED
2010-09-07
140

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. A
MFG. APPR.		D4095 SHEET 3 OF 4
APPROVED		TITLE SCALE
DE APPR.		WEARPLATE NTS
DATE	10.04.20	COPYRIGHT © 2010 BY DART AEROSPACE LTD
		THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



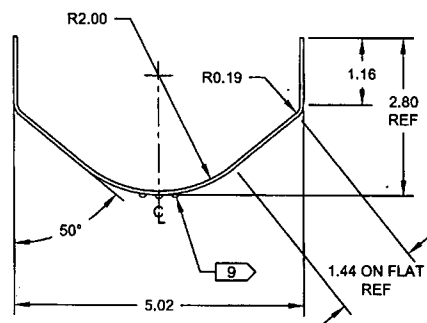
DETAIL A: TAB DETAIL

SCALE 4X
C3-2
C8-3



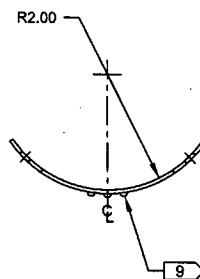
DETAIL B: JOGGLE DETAIL

SCALE 4X
B2-2
B5-2
B4-3
B7-3



SECTION C-C

SCALE 2X
B5-2
B4-3



SECTION D-D

SCALE 2X

58116

RELEASED
2010-09-07

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4095	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	NTS
DATE	10.04.20	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

Location/Lot Activity

October 7, 2010 1:36:07 PM

Page 1 of 1

Criteria : All Items All Locations Lot: 58116 All Transaction Types All Dates Report on Locations & Lots

Transaction Type	Item ID/ Item Name	Warehouse Location ID	Reason	Employee ID Location Code	Loc Trans Date	LocQtyPrior/ Location Qty	Lot Number	LotQtyPrior/ Lot Qty	Shelf Life Date Lot Code	Extended Cost
Issue	D4095-3 / Wearplate	Main Warehouse	58138	FAUT01		2.0000		2.0000		
		ENG			4/27/10	-2.0000	58116	-2.0000		-\$89.59
								-2.0000		-\$89.59
WIP Receipt	D4095-3 / Wearplate	Main Warehouse	58116	FAUT01		0.0000		0.0000		
		ENG			4/27/10	2.0000	58116	2.0000		\$89.59
								2.0000		\$89.59

✓

✓

✓

✓